



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBEM632V3008102-11

Job Sheet 180317



Y-S

SNIP
7-23

Part No: RBEM632V3008102-11

Job Qty: 8 ea

Part Name: Disk



Part Weight: 0 lbs

Status: At Planning

Priority: High

Job Created: 7/4/18

Job Tracking No:

Due Date: 7/4/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBEM632V3008102 Rev. C IPP Rev. A 18.06.05 new issue DP Verify DD

Ship Via:

DAS
13
9-88

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	7/4/18	7/4/18	0.00	0.00	Start Up Machining-4		JK
100	Mori Seiki	8 pcs	7/4/18	7/4/18	0.50	0.80	MORI SL2500		JK
110	QC	8 pcs	7/4/18	7/4/18	0.00	0.00	QC2 Machining-5		JK
120	QC	8 pcs	7/4/18	7/4/18	0.00	0.00	QC8 Machining-5		JK
130	Small Fab	8 pcs	7/4/18	7/4/18	0.00	0.80	Small Fab-6		JK
140	QC	8 pcs	7/4/18	7/4/18	0.00	0.00	QC5		SB
150	Packaging	8 pcs	7/4/18	7/4/18	0.00	0.00	Packaging3-2		SP/8-7-31
160	QC21-SA	8 Ea	7/4/18	7/4/18	0.00	0.00	QC21		DAS JUL 31 2018

Part Op 100 - 1-Machine as per folio FC161 FOLIO REV: AA DWG REV: C 2-Deburr

Descriptions: 130 - Fill engraving with black paint.

150 - IDENTIFY AND STOCK

3-75

CA/35

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELINR2.500W	Delrin Round Bar 2.500	.3464 ft (.0433 ea)	90-Start up Operation	135615-.34

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MDELINR2.500W	0	5	0

Part Specifications

Specifications could not be found.

Plex 7/4/18 1:10 PM dart.logan.david



Container No: S097198



Part: RBEM632V3008102-11

Job No: 180317

Serial No/Batch: S097198

Revision: C

Inspector:

Exp Date:

Instructions:

Date: 07/28/18

180317

Page 1 of 1

2.37	$\pm .01$	2.37
0.217	$\pm .005$	.217
0.460 x 90°	$\pm .01 \pm .5^\circ$	.46 x 90°
.03 x 45°	$\pm .01 \pm .5^\circ$	.03 x 45°
.32	$\pm .01$	.32

Measured by:	dh
Date:	18-7-28

Engineering Approval:
(If necessary)

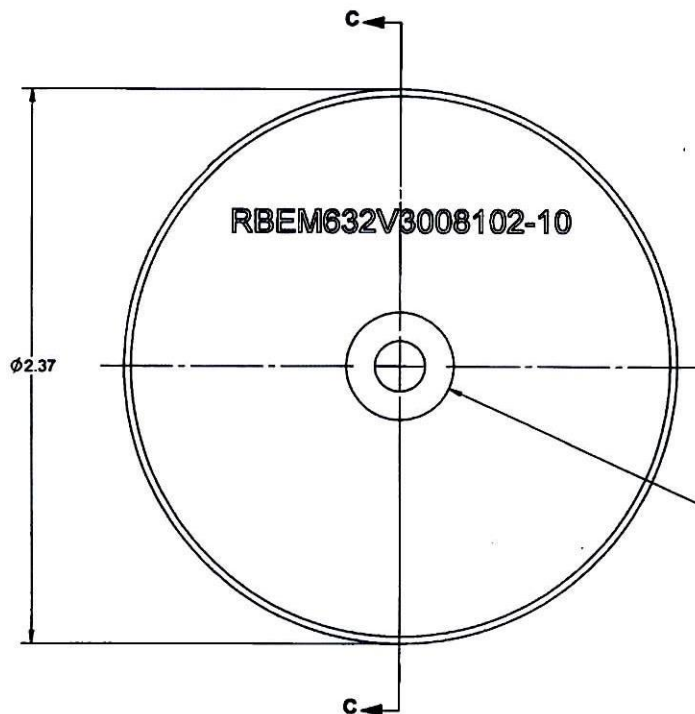
Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

WORK ORDER NON-CONFORMANCE / UPDATE

Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER :					

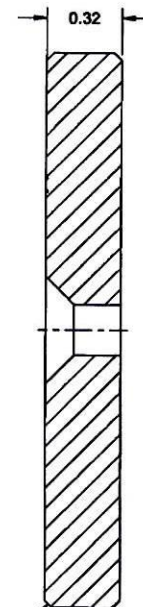


RBEM632V3008102-10

2.37

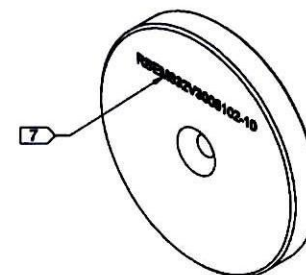
0.217 THRU ALL
0.46 X 90°

RBEM632V3008102-11 DISC



0.03 X 45° CMF
2 PL

SECTION C-C



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 130317
20180710
72

NOTES:

1) MATERIAL: WHITE DELRIN / ACETAL ASTM D6100

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: MACHINE ENGRAVE PER CAD MODEL AS SHOWN AND FILL WITH BLACK INK

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MZA	TOOL PART #	REV. C
MFG. APPR.	DP	RBEM632V3008102	SHEET 12 OF 13
APPROVED	MZA	TITLE	SCALE
DATE 6/6/2018		OUTPUT FLANGE SEAL EXCHANGE	NTS
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